

movement at a constant speed. Usually, the yarn to be wound runs over the surface of a yarn guide which is located between the combining device and the support and moves in a backward and forward motion parallel to the longitudinal axis of the rotating support.

Page 2, lines 14-29, please replace the paragraph with the following paragraph:

Application FR 2,703,671 teaches a method of winding yarn for the formation of a frustoconical bobbin using a drawn yarn that has come directly from a bushing and has not undergone a twisting operation. The yarn, which is taken through the yarn guide, is wound around a support fastened at its base to a flange and placed vertically, the yarn guide moving in a backward and forward motion parallel to the longitudinal axis of the support. To produce the frustoconical shape of the bobbin, the solution proposed is to use a drawing device, placed after the device for combining the filaments and a dancer roll placed between the drawing device and the yarn guide. The dancer roll can rotate freely about its spindle, which is fastened to the end of a spring-loaded arm, thereby making it possible to impose a predetermined tension in the yarn to be wound.

Page 5, line 25 to page 6, line 11, please replace the paragraph with the following paragraph:

According to the invention, the method of winding a yarn in superposed layers onto a cylindrical support of longitudinal axis x and fastened around a spindle driven in a rotational movement, in which the yarn is wound by running over a yarn guide which moves with a backward and forward motion parallel to the x axis of the support and is controlled so as to form a bobbin whose shape has two frustoconical ends called the base cone and the unwind cone respectively, having respective generatrices which are inclined with respect to the x axis at two different respective acute angles, and a main body of frustoconical shape which joins the two frustoconical ends and the two end sections of which form the two bases of the

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respective two cones base and unwind cones with different diameters, D1 and D2 respectively, is characterized in that it comprises two rules governing the movement of the yarn guide, a first rule which is used to form part of the base cone, the last layer of yarn deposited according to this first rule going as far as the end of the unwind cone, and a second rule which is used to terminate the said base cone that has been started and, concomitantly, to form the main body and the unwind cone, the first layer of yarn deposited according to the second rule being parallel to the last layer deposited according to the first rule.

Page 6, lines 12-19, please replace the paragraph with the following paragraph:

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According to one characteristic of the invention, the first rule governing the movement of the yarn guide consists in establishing backward and forward motions parallel to the axis of the support between an initial position (x_0) and a final position (x_2) which correspond, in projection perpendicular to the support, to each of the end sections of the bobbin respectively, each backward and forward motion being defined by:

Page 7, lines 13-24, please replace the paragraph with the following paragraph:

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According to another characteristic, the second rule governing the movement of the yarn guide consists in executing backward and forward motions parallel to the axis of the support, between an initial position which constitutes the final position (x_2) of the yarn guide according to the first rule and a terminal position (x_1) which lies between the final position (x_2) according to the first rule, and which is dictated by the value of the diameter D2 desired for the unwind cone to be formed, and the starting position for the last movement according to the first rule, each backward and forward motion being defined by:

Page 12, lines 20-25, please replace the paragraph with the following paragraph:

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The yarn guide 34 is driven with a horizontal backward and forward motion M parallel to the longitudinal axis X of the support and, preferably, with a horizontal backward

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and forward motion N perpendicular to the X axis, the latter motion being carried out concomitantly with the motion M as will be explained later.

Page 15, lines 27-34, please replace the paragraph with the following paragraph:

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The winding method according to the invention is based on the backward and forward motion imposed on the yarn guide 34. It is decomposed into two steps according to two respective rules governing the movement, the first creating part of the generatrix L2 of the base cone 12 and the second terminating the generatrix L2, and then simultaneously forming the generatrices L1 and L3 of the body 11 and of the unwind cone 13 respectively.

Page 16, lines 4-8, please replace the paragraph with the following paragraph:

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Between the positions x_0 and x_2 , the yarn guide 34 performs several backward and forward movements d_i , each of which comprises a forward travel a_i towards the position x_2 and a return travel R_i towards the initial position x_0 .

Page 17, lines 1-3, please replace the paragraph with the following paragraph:

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Consequently, the yarn guide 34 performs, between the position x_0 and the position x_2 , backward and forward movements, each of which defines:

IN THE CLAIMS

Please cancel Claim 14.

Please amend the claims as shown on the marked-up copy following this amendment to read as follows:

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1. (Amended) A method of winding a yarn in a plurality of superposed layers onto a cylindrical support (20) having a longitudinal axis (X) and fastened around a spindle (21) driven in a rotational movement, in which the yarn is wound by running over a yarn guide (34) which moves in a backward and forward motion (M) parallel to the axis (X) of the